



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4647-1
Job Sheet 167119



Part No: D4647-1

Job Qty: 30 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	30 Ea		11/9/17	0.00	0.00	Start up container	SC
110	Waterjet	30 pcs		11/9/17	0.00	2.19	Waterjet1	SC
120	QC	30 pcs		11/9/17	0.00	0.00	QC2	DSX
130	QC	30 pcs		11/9/17	0.00	0.00	QC8	38
140	Brake NC	30 pcs		11/9/17	0.03	2.25	Brake NC 2	DAS-80 SP
150	QC	30 pcs		11/9/17	0.00	0.00	QC5	38
160	HandFinish	30 pcs		11/10/17	0.00	0.84	HandFinish1	2017-11-27 JSL
170	QC	30 pcs		11/10/17	0.00	0.00	QC7	38
180	Packaging	30 pcs		11/10/17	0.00	0.00	Packaging3	JK 9-89
190	QC21-SA	30 Ea		11/10/17	0.00	0.00	QC21	DAS 21 9-89

NOV 3 0 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.040	4	72	0	0

Part Specifications

Specifications could not be found.

Plex 10/24/17 4:44 PM dart.poulin.mario

MF004

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																										
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval																																								
Description Work Order Deviation		Disposition		Completed By																																								
Job No: 167119 Mfg Date: 10/28/17 Start up Operation 30 D4647-1 Change No: Quantity: Operation: Revision: PART NO: Doublet S003354 DART AEROSPACE		 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		_____ and / Supervisor Approval Verification																																								
				_____ QA Coordinator Approval																																								
				_____ Misread																																								
				_____ Turning Sequence																																								
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> </tr> </thead> <tbody> <tr> <td style="width:33%;">Environment ☐</td> <td style="width:33%;">No Re-verification ☐</td> <td style="width:33%;">Press ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bench ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Center ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Crack ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Critical ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuts ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> </tr> </tbody> </table>						Root Cause			Environment ☐	No Re-verification ☐	Press ☐	Design ☐	Operator ☐	Bench ☐	Doc/Data ☐	Offset/Setup ☐	Center ☐	Equip/Tooling ☐	Supplier ☐	Crack ☐	Handling/Pre ☐	Training ☐	Critical ☐	Material ☐	Use for Testing ☐	Cuts ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐	
Root Cause																																												
Environment ☐	No Re-verification ☐	Press ☐																																										
Design ☐	Operator ☐	Bench ☐																																										
Doc/Data ☐	Offset/Setup ☐	Center ☐																																										
Equip/Tooling ☐	Supplier ☐	Crack ☐																																										
Handling/Pre ☐	Training ☐	Critical ☐																																										
Material ☐	Use for Testing ☐	Cuts ☐																																										
Internal Transport ☐	Poor Information ☐	Crushing ☐																																										
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐																																										
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐																																										
Substation ☐	Process Improvement ☐	Marks/Chatter ☐																																										
Past Expiry Date ☐	Manufacturing Process ☐																																											
Misidentified ☐	Past Due ☐																																											
OTHER : _____																																												

